

# Work Order ID 52148

Thursday, September 17, 2009 8:09:43 AM



Page 1

Item ID: D209-669-014

Accept



Setup Start



Revision ID: B

Stop



Item Name: Skidtube RH

Start Date: 9/18/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*RL ml*

Date:

*09-9-17*

Tooling:

Date:

Run

Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D209-669-014

Rev B

DSI 9450

Rev A

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D209-669-014 CHG003

*809/09/02*

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*809/09/30 (1)*

**Work Order ID 52148**

Thursday, September 17, 2009 8:09:43 AM

Page 2

Item ID: D209-669-014

Accept

Revision ID: B

Item Name: Skidtube RH

Start Date: 9/18/2009 Start Qty: 1.00

Required Date: 10/9/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

27802/10/02

130

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD209-669-014  
Location: 

09/10/02 (1)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/05

09-10-2

# Picklist.Print

Thursday, September 17, 2009 8:09:42 AM

Page 1

10

Work Order ID: 52148



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D209-669-043RevB Manufactured No

110 Each 3.0000 41.0000



Replacement Skidtube



B52110 9/18/09 SP

Warehouse Loc Qty Loc Code  
Location

Premier

Mezz

3

22797

1

39205

1

39206

1

D2917-2RevB Manufactured No

110 Each 3.0000 2.0000



Saddle RH



B52128 9/10/09

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

FG

3

51328

3

D2918-2RevB Manufactured No

110 Each 3.0000 2.0000



Saddle RH



9/30/09

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST

3

43138

1

51330

2

B52132

22

# Picklist Print

Thursday, September 17, 2009 8:09:42 AM

Work Order ID: 52148



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-51A		Purchased	No			110	Each	354.0000	8.0000			
---------	--	-----------	----	--	--	-----	------	----------	--------	--	--	--



Bolt

*Handwritten signature and date: 9/30/09*

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	354	
110328	2	
111635	102	
112314	100	
112489	100	
112641	50	

D2570RevB

Manufactured No

110 Each 139.0000 24.0000



Bushing

*Handwritten signature and date: 9/30/09*

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	15	
47246	15	
Main Warehouse		
ST36	124	
50356	124	

*Handwritten: 351519*

*Handwritten circled: 24K*

# Picklist Print

Thursday, September 17, 2009 8:09:42 AM

Work Order ID: 52148



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

S

MS21042L4

Purchased

No

110

Each

8,148.000

24.0000



Nut



*Ep 09/09/30*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8148

107499

5

108145

4

110450

1

110507

184

111827

5996

112314

1893

15924

0

7690

24

8182

41

*29*

S

AN5-36A

Purchased

No

110

Each

555.0000

4.0000



Bolt



*Ep 09/09/30*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

555

109545

11

110467

7

110731

4

112243

20

112314

463

112385

50

*4*

# Picklist Print

Page 4

Thursday, September 17, 2009 8:09:42 AM

Work Order ID: 52148



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516  Washer		Purchased	No			110	Each	1,097.000	8.0000		09/09/30	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1097

100564

2

106167

6

107534

34

107959

43

108246

46

108672

2

109059

49

109752

22

110363

46

110523

57

111279

43

112082

247

112314

500

MS21042L5

Purchased

No

110

Each

1,279.000 4.0000

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1279

110382

10

111636

269

112314

1000

Thursday, September 17, 2009 8:09:42 AM

Shop Packet Print

Page 4

# Picklist Print

Page 5

Thursday, September 17, 2009 8:09:42 AM

Work Order ID: 52148



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH


Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-7A  Bolt		Purchased	No			110	Each	201.0000	16.0000		<i>9/30/09/30</i>	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

201

111668

1

112314

50

112385

50

112641

100

16

Thursday, September 17, 2009 8:09:42 AM

Shop Packet Print

Page 5

# Picklist Print

Page 6

Thursday, September 17, 2009 8:09:42 AM

Work Order ID: 52148



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S AN960JD416  Washer		Purchased	No			110	Each	8,313.000	32.0000		<u>9/09/09/30</u>	

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	8313
102929	2
105906	4
106277	2
107321	23
107939	114
108161	553
108827	31
109249	69
110523	340
111279	101
111916	2187
112314	4887
16941	0

S D2929RevB

Manufactured No



Spacer

110 Each 15.0000 2.0000



Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	15
43376	15

9/09/09/30  
2

Thursday, September 17, 2009 8:09:42 AM

Shop Packet Print

Page 6



# Picklist Print

Page 7

Thursday, September 17, 2009 8:09:42 AM

Work Order ID: 52148

Parent Item: D209-669-014RevB

Parent Item Name: Skidtube RH


Comments:

Start Date: 9/18/2009

Required Date: 10/9/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S D2930RevB  Spacer		Manufactured	No			110	Each	11.0000	2.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

11

43378

11

S D3405-041RevB  
  
Lug Assembly

Manufactured No

110

Each

10.0000

1.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

10

51254

10

S AN4C47A  
  
Bolt

Purchased No

110

Each

222.0000

4.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

222

110847

4

112431

18

112489

100

112641

100

*EP 09/09/30*

*2*  
*EP 09/09/30*

*B51673 (10)*

*3*  
*EP 09/09/30*

*4*

Thursday, September 17, 2009 8:09:42 AM

Shop Packet Print

Page 7

# Picklist Print

Thursday, September 17, 2009 8:09:42 AM

Work Order ID: 52148



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-4  Nut		Purchased	No			110	Each	1,397.000	5.0000			

*Handwritten signature*  
9/30/09/30

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
OFFSHORE		
FG	40	
104603	40	
Main Warehouse		
ST	1357	
111819	35	
112243	22	
112314	1000	
112492	300	

*Handwritten number 5*

D3405-043RevB

Manufactured No



Lug Assembly

110 Each 12.0000 1.0000



*Handwritten signature*  
9/30/09/30

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
ST	12	
46589	1	
46863	1	
51255	10	

*Handwritten text*  
B51652 (1X)

# Picklist Print

Thursday, September 17, 2009 8:09:42 AM

Work Order ID: 52148

Parent Item: D209-669-014RevB

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/18/2009

Required Date: 10/9/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3407-041RevE Manufactured No

110

Each

35.0000

1.0000



Tow Ring



9/30/09

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

3

35780

3

Main Warehouse

ST

1

48356

1

Main Warehouse

ST464

31

51659

31

D3456-1RevA Manufactured No

110

Each

232.0000

1.0000



Washer



9/30/09

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

7

25701

7

Main Warehouse

ST

225

46752

25

51653

200

# Picklist Print

Page 10

Thursday, September 17, 2009 8:09:42 AM

Work Order ID: 52148



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3417-5RevE		Manufactured	No			110	Each	152.0000	2.0000			



Washer



*9/30/09/30*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

152

51649

152

2

Thursday, September 17, 2009 8:09:42 AM

Shop Packet Print

Page 10

# **DART SERVICE INSTRUCTION**

**TO AMEND INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 52148

## **INSTRUCTIONS:**

1) FOR D209-669-011/-012/-013/-014 SKID TUBES @ CHANGE 003 AND SUBSEQUENT, MODIFY THE FOLLOWING:

- a) REPLACE THE D2968-041 TOW RING WITH THE D3407-041 TOW RING ASSEMBLY.
- b) REPLACE THE D2736-1 AND D2736-3 GHW LUGS WITH THE D3405-041 AND D3405-043 LUG ASSEMBLIES.
- c) AMEND THE PARTS LIST IN SECTION 5.0 OF INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B AS SHOWN ON PAGE 2 OF THIS DSI.

NOTE: ALL INSTALLATION FASTENERS FOR THE ABOVE CHANGES HAVE BEEN UPDATED. SEE THE AMENDED PARTS LIST ON PAGE 2 FOR DETAILS.

A	NEW ISSUE	AJS	09.02.24
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
DATE	09.02.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR OTHERWISE REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

# 5.0 PARTS LIST

52148

ITEM	QTY -011	QTY -012	QTY -013	QTY -014	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X						D209-669-011	SKIDTUBE INSTALLATION, LH (AH-1W/J)
		X					D209-669-012	SKIDTUBE INSTALLATION, RH (AH-1W/J)
			X				D209-669-013	SKIDTUBE INSTALLATION, LH (AH-1P/F/S)
				X			D209-669-014	SKIDTUBE INSTALLATION, RH (AH-1P/F/S)
	1	1			X		D209-669-041	REPLACEMENT SKIDTUBE (AH-1W/J)
			1	1		X	D209-669-043	REPLACEMENT SKIDTUBE (AH-1P/F/S)

IS:

50	4	4	1	1			D3405-041	LUG ASSEMBLY
51	8	8	4	4			AN4C47A	BOLT
52	16	16	8	8			D2570	BUSHING
53	8	8	4	4			MS21043-4	NUT
54			1	1			D3405-043	LUG ASSEMBLY
60	1	1	1	1			D3407-041	TOW RING ASSEMBLY
61	1	1	1	1			D3456-1	WASHER
62	1	1	1	1			MS21043-4	NUT
63	2	2	2	2			D3417-5	WASHER

WAS:

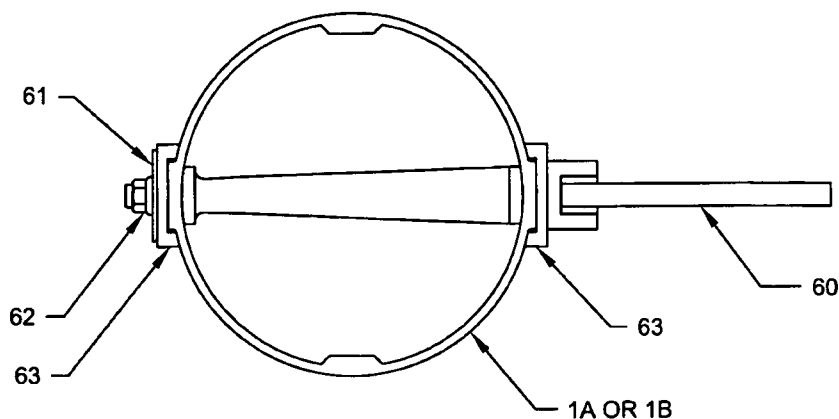
50	4	4	1	1			D2736-1	GHW LUG
51	8	8	4	4			AN4-46A	BOLT
52	16	16	8	8			D2570	BUSHING
53	8	8	4	4			MS21042L4	NUT (OR MS21042-4)
54			1	1			D2736-3	GHW LUG
60	1	1	1	1			D2968-041	TOW RING
61	1	1	1	1			AN970-4	WASHER
62	1	1	1	1			MS21042L4	NUT (OR MS21042-4)

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9450 SHEET 2 OF 3
APPROVED		TITLE SCALE
DE APPR.		SKIDTUBE INSTALLATIONS NTS
DATE	09.02.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.

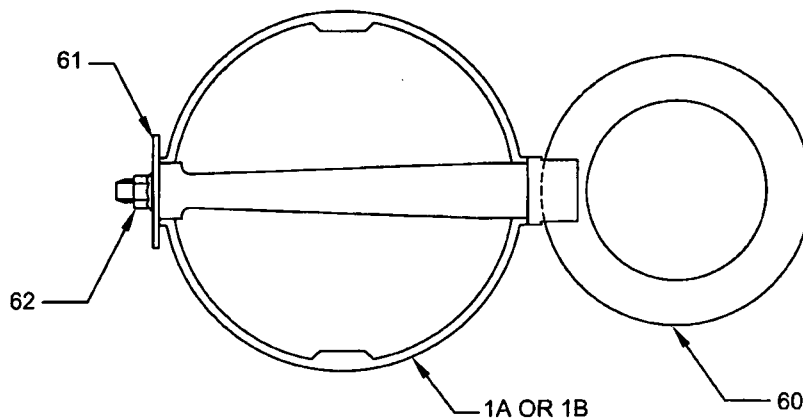
INSTALL TOW RING ASSEMBLY AS SHOWN BELOW (REFER TO SECTION F-F OF IIN-D209-669 REV. B.

52148

IS:



WAS:



NO PICTORIAL CHANGE REQUIRED FOR GROUND HANDLING WHEEL LUG CHANGES.

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
DATE	09.02.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT ANOTHER PERMISSION FROM DART AEROSPACE LTD</small>	

#### 4.0 WEIGHT AND BALANCE

The following weight and balance information is for the replacement Dart parts. The weight and balance of the skidtubes that are being removed from the aircraft is the responsibility of the installer.

Installation	Weight	LONGITUDINAL	
		Arm	Moment
D209-669-011/-012	49.6 lb	170.4 in	8452 in lb
SKIDTUBE INSTALLATION	22.5 kg	4.33 m	97.4 m kg
D209-669-013/-014	43.8 lb	176.5 in	7731 in lb
SKIDTUBE INSTALLATION	19.9 kg	4.48 m	89.2 m kg

REFERENCE ONLY

#### 5.0 PARTS LIST

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -041	Qty -043	Part Number	Description
	X						D209-669-011	SKIDTUBE INSTALLATION, LH (AH-1W/J)
		X					D209-669-012	SKIDTUBE INSTALLATION, RH (AH-1W/J)
			X				D209-669-013	SKIDTUBE INSTALLATION, LH (AH-1P/F/S)
				X			D209-669-014	SKIDTUBE INSTALLATION, RH (AH-1P/F/S)
	1	1			X		D209-669-041	REPLACEMENT SKIDTUBE (AH-1W/J)
			1	1		X	D209-669-043	REPLACEMENT SKIDTUBE (AH-1P/F/S)
1A					1		D2906-041	SKIDTUBE ASSEMBLY
1B						1	D2906-043	SKIDTUBE ASSEMBLY
2	1		2				D2917-1	OUTER SADDLE (FWD, LH)
3		1		2			D2917-2	OUTER SADDLE (FWD, RH)
4	1		2				D2918-1	INNER SADDLE (FWD, LH)
5		1		2			D2918-2	INNER SADDLE (FWD, RH)
6	1						D2919-1	OUTER SADDLE (AFT, LH)
7		1					D2919-2	OUTER SADDLE (AFT, RH)
8	1						D2920-1	INNER SADDLE (AFT, LH)
9		1					D2920-2	INNER SADDLE (AFT, RH)
10	8	8	8	8			AN4-51A	BOLT
11	16	16	16	16			D2570	BUSHINGS
12	8	8	8	8			MS21042L4	NUT (OR MS21042-4)
13	2	2	4	4			AN5-36A	BOLT
14	2	2					AN5-41A	BOLT
15	8	8	8	8			AN960JD516	WASHER
16	4	4	4	4			MS21042L5	NUT (OR MS21042-5)
17	16	16	16	16			AN4-7A	BOLT
18	32	32	32	32			AN960JD416	WASHER
19	16	16	16	16			MS21042L4	NUT (OR MS21042-4)

CONTINUED ON NEXT PAGE

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Revision: B  
Date: 07.08.23



## CONTINUED FROM PREVIOUS PAGE

20	2	2	2	2			D2929	SPACER
21	2	2	2	2			D2930	SPACER
*30A					1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
*30B					1	1	D3566-1	GASKET
*31A					1		D3564-15	WEARSHOE (REPLACES 18" D2577-5)
*31B					1		D3566-15	GASKET
*32A					1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
*32B					1	1	D3566-1	GASKET
*33A					1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
*33B					1	1	D3566-5	GASKET
*34					50	44	AN3C4A	BOLT (REPLACES AN3-4A)
*35					50	44	AN960C10L	WASHER (REPLACES AN960JD10L)
*36					50	44	AKS7-1032-130	INSERT (OR ALS7-1032-130, OR ALS4-1032-130, OR AKS4-1032-130)
*37					12	14	D2594-1	PLUG
*38					12	14	D2594-3	O-RING
*40					2	2	D2855	AFT CAP
*41					4	4	AN3-5A	BOLT
*42					4	4	AN960JD10L	WASHER
*43					4	4	AKS7-1032-225	INSERT (OR ALS7-1032-225, OR ALS4-1032-225, OR AKS4-1032-225)
50	4	4	1	1			D2736-1	GHW LUG
51	8	8	4	4			AN4-46A	BOLT
52	16	16	8	8			D2570	BUSHING
53	8	8	4	4			MS21042L4	NUT (OR MS21042-4)
54			1	1			D2736-3	LUG ASSEMBLY
60	1	1	1	1			D2968-041	TOW RING
61	1	1	1	1			AN970-4	WASHER
62	1	1	1	1			MS21042L4	NUT (OR MS21042-4)

\* DENOTES THAT PART IS INCLUDED WITH D2906-041/-043 SKIDTUBE ASSEMBLY

52148